

Date: Wednesday, 09/04/2008 9:18:31 AM  
User: Julie Lecocq

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 38505 2  
Estimate Number : 13098  
P.O. Number :  
This Issue : 09/04/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : THERMOFORMING  
Previous Run : 37665  
Written By :  
Checked & Approved By : JD 08.4.09  
Comment : Est. Rev. A 07/12/13 DL verified by:DD

Drawing Name : PANEL-350 AFT CANOPY  
Part Number : D36561  
Drawing Number : D3656 REV A  
Project Number : 00204  
Drawing Revision : A  
Material :  
Due Date : 30/04/2008 Qty: 2 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MLEXS093F600607

GE PLASTICS LEXAN SHEET



Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s)  
GE PLASTICS LEXAN SHEET  
batch: M105494

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

3.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1and Folio FTA 015 using tool DT 8986

Dwg. Rev. A

Folio Rev. A

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part





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Drawing Name: PANEL-350 AFT CANOPY

Job Number: 38505

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



08/04/08 Wh x2

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/08 Wh

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

x2

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/08 Wh

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

x2

8.0

QC5

INSPECT WORK TO CURRENT STEP



08/04/08 Wh

Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

MP 39387 08/05/08 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08 Wh

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/05/08 Wh





DART AEROSPACE LTD	WORK ORDER: 38505
Description: PANEL 350 AFT CANOPY	Part Number: D36561
Inspection Dwg: D3656 Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	[Signature]
Acceptable shape definition	[Signature]
Acceptable texture retention	[Signature]
Free of visual flaws (bumps, cracks, voids, etc.)	[Signature]

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D36561 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7	.1	24.7	✓		Tape	Inside good color
0.070	MIN.	0.083	✓		Vern	slightly long but gets to meet to fit by customer
0.050	MIN.	0.063	✓		Vern	

Measured by: [Signature]  
Date: 08-04-10

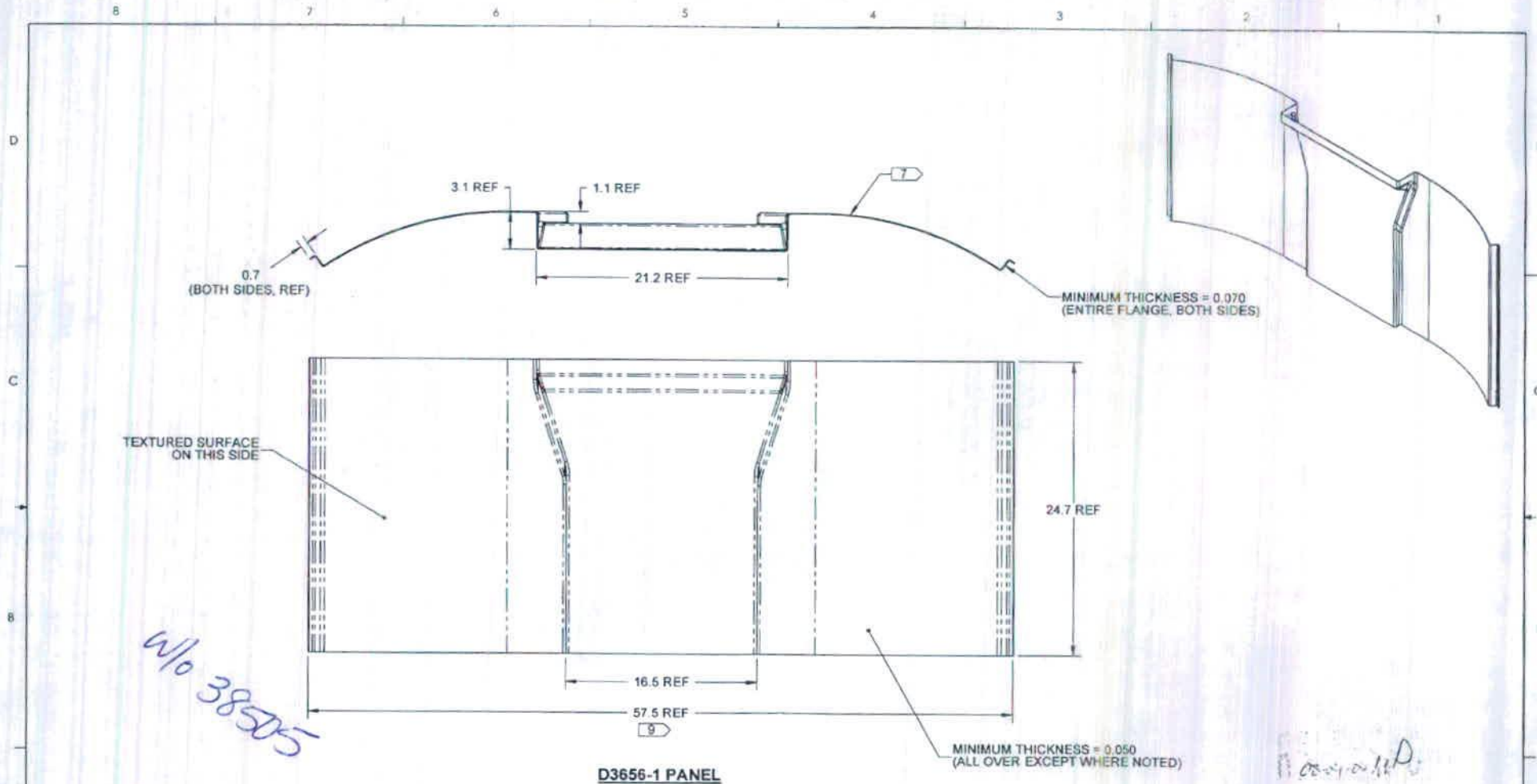
Audited by: [Signature]  
Date: 08-04-10

Prototype Approval: [Signature]  
Date: 08-04-10

Rev	Date	Change	Revised by	Approved
		New Issue		

[Signature]





# NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY58133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	LE	08.03.03
DESIGN	LE		
DRAWN	LE		
CHECKED	RE		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	08.03.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3656  
REV. A  
SHEET 1 OF 2

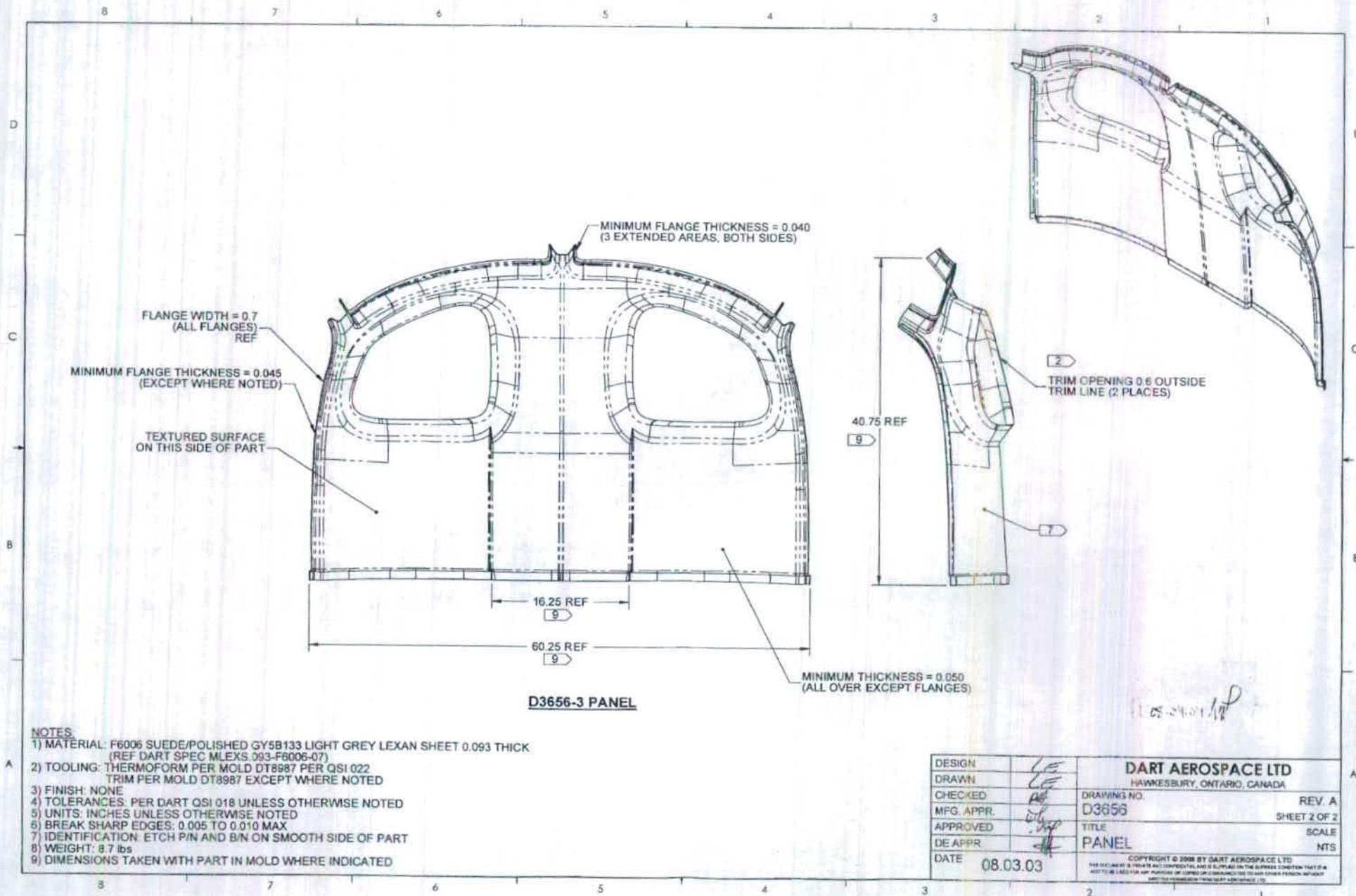
TITLE PANEL  
SCALE NTS

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DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	DE	DRAWING NO.	REV. A
MFG. APPR.	DE	D3656	SHEET 2 OF 2
APPROVED	DE	TITLE	SCALE
DE APPR	DE	PANEL	NTS
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